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(21) Application number:	04116975	(71) Applicant:	SUMITOMO METAL IND LTD
(22) Date of filing:	08.04.1992	(72) Inventor:	OKAZAWA TORU

**(54) MANUFACTURE OF HIGH STRENGTH
CORROSION RESISTANT STEEL PIPE**

(57) Abstract:

PURPOSE: To easily obtain an oil well pipe satisfying both high strength and high corrosion resistance and furthermore small in bending by executing prescribed bend removing after hardening and tempering repeated for two times for a steel pipe contg. specified C, Si, Mn, P, S, Cr, Mo, Al, Nb or the like.

CONSTITUTION: Steel contg. $\leq 0.3\%$ C, 0.05 to 1% Si, 0.3 to 1% Mn, $\leq 0.03\%$ P, $\leq 0.03\%$ S, 0.3 to 1.5% Cr, 0.1 to 2% Mo, 0.01 to 0.05% Al and $\leq 0.015\%$ N,

contg. one or more kinds among 0.01 to 0.04% Nb, 0.03 to 0.1% V, 0.01 to 0.05% Ti, 0.001 to 0.005% B and 0.001 to 0.005% Ca, and the balance Fe is melted. The steel pipe constituted of the steel is subjected to primary hardening and tempering and is thereafter subjected to perfect cold or warm bend removing. Next, it is subjected to secondary hardening and tempering and is thereafter subjected to slight warm bend removing or the like, by which the objective steel pipe small in bending and having a uniform distribution of the hardness in the direction of the thickness can be obtd.

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